

Date: Thursday, 06/12/2007 10:25:19 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D135-751-011 REWORK
 Job Number : 36164
 Estimate Number : 10804
 P.O. Number : N/A Part Number : D135751011
 This Issue : 06/12/2007 S.O. No. : N/A Drawing Number : ECN1036
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 00015 Material : N/A
 Written By : Due Date : 13/12/2007 Qty: 1 Um: Each
 Checked & Approved By :
 Comment :

Additional Product

DART			
TRANSPORT CANADA APPROVAL #09-89			
PN	D135-751-011	CHG	CHG001
DFSC	Skidtube	SIC	SR01709SE
LOT	B28957	SIC	
MODPL	EC135 P1/P2/T1/T2	SIC	
US PATENT # 7,255,484		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

Job Number:



Seq. #: Machine Or Operation:

1.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D135-751-011 B28957 9 26456

2.0 D135751011

SKIDTUBE INSTALLATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 SKIDTUBE INSTALLATION

3.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE 1 X D3508-7 REV.B WEARPLATE
 REMOVE 2 X D3512-1 REV.B WEARPLATE
 SCRAP BOTH
 REWORK SKID PER DRWG IAW D3507 REV.C
 (DRILLING DETAIL HAS CHANGED)

ADP
 7-12-6

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:25:19 AM
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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36164

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ALUMINUM ROD BM 105138

WELD 2 X D3504-5 CROSSBOLT SPACERS
PER DRWG D3507 REV.C

BE 07-12-13

6.0

D35045

CROSSBOLT SPACER



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
CROSSBOLT SPACER

B 36181

BE 07-12-13

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QCC 5/12/14

Qc9 07/12/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REMOVE ALL EXISTING PARTS:
WEARPLATES, CAPS, INSERTS, BOLTS, WASHERS
KEEP EXISTING WEARPLATES & CAPS
DISCARD INSERTS, BOLTS & WASHERS

N/A
RH
07/12/17

MASK D3506-1/-3 DOUBLER, PLUG HOLES
RE-POWDER COAT PER QSI005
(STRIP IF NECESSARY)

7m

BK 07-12-17

07/12/17 (1X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 07/12/17 (1)

10.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)
Insert

NOT
REQ'D
07.12.17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: D135-751-011 REWORK

Job Number: 36164

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

ALS41032225

Insert



NOT
REQ'D



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Insert

PL
07.12.17

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RE-ASSEMBLE CAPS (SIKAFLEX) B
& WEARPLATES
PER DRWG D3507 REV.C

PICK NEW 1 X D3508-7 REV.C B
INSTALL PER DRWG D3507 REV.C

PICK 4 X D3492-043 PLUGS B
INSTALL PER DRWG D3507 REV.C

m 105585

4x D3492041
B 35588

B 36179

2x D3492047

B 27776

FL 07/12/17 ①

B 35840

Wingwalk

B 106332

m-1 07/12/17 ①

13.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PLUG ASSEMBLY

B 35840

FL

14.0

D35087

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARPLATE

B 36179

FL

15.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)
BOLT

m 106431

FL

16.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)
washer

m 106302

FL 07/12/17 ①

1x D3558-7

B 30001

FL

1x D3558-1

B 29998

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36164

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt *m106552*

FL

18.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Screw *m15072*

FL

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/08 (X)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ENSURE ORIGINAL KIT IS INCLUDED
ADD:

2 X D3512-1 **REV.C** WEARPLATE B

381197
~~*361180*~~

21.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
WEARPLATE *B31197*

NO Gant
B36180 New

AS 7/12/19

(X)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 7/12/19 (X)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP
USING NEW B/N - CHG 001

PRAT 6/12/21

36164

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 08/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:25:19 AM
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Drawing Name: D135-751-011 REWORK

Job Number: 36164

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.12.07
POSITIVE RECALL

EFFECTIVE 07.12.07 AUTH CA

RELEASED 07.12.07 DATE 6

Don 12/26

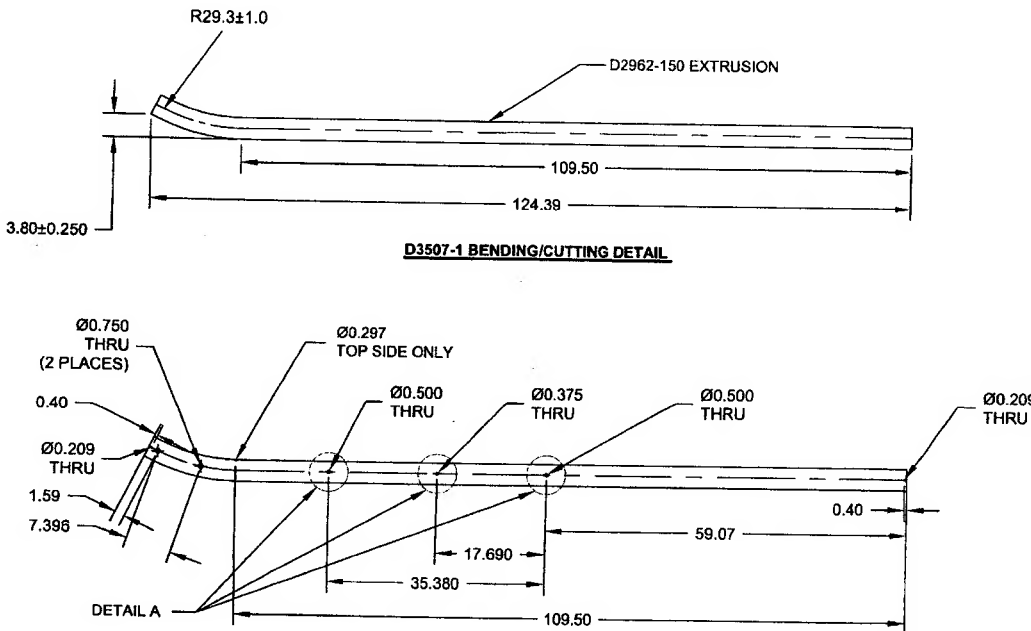
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

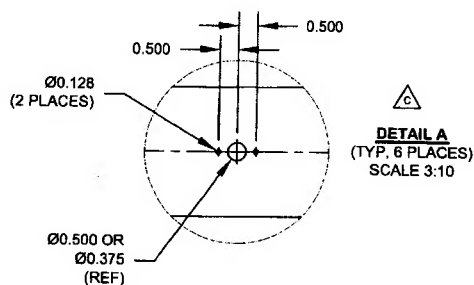
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL

D3507-1 DRILLING DETAIL



Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

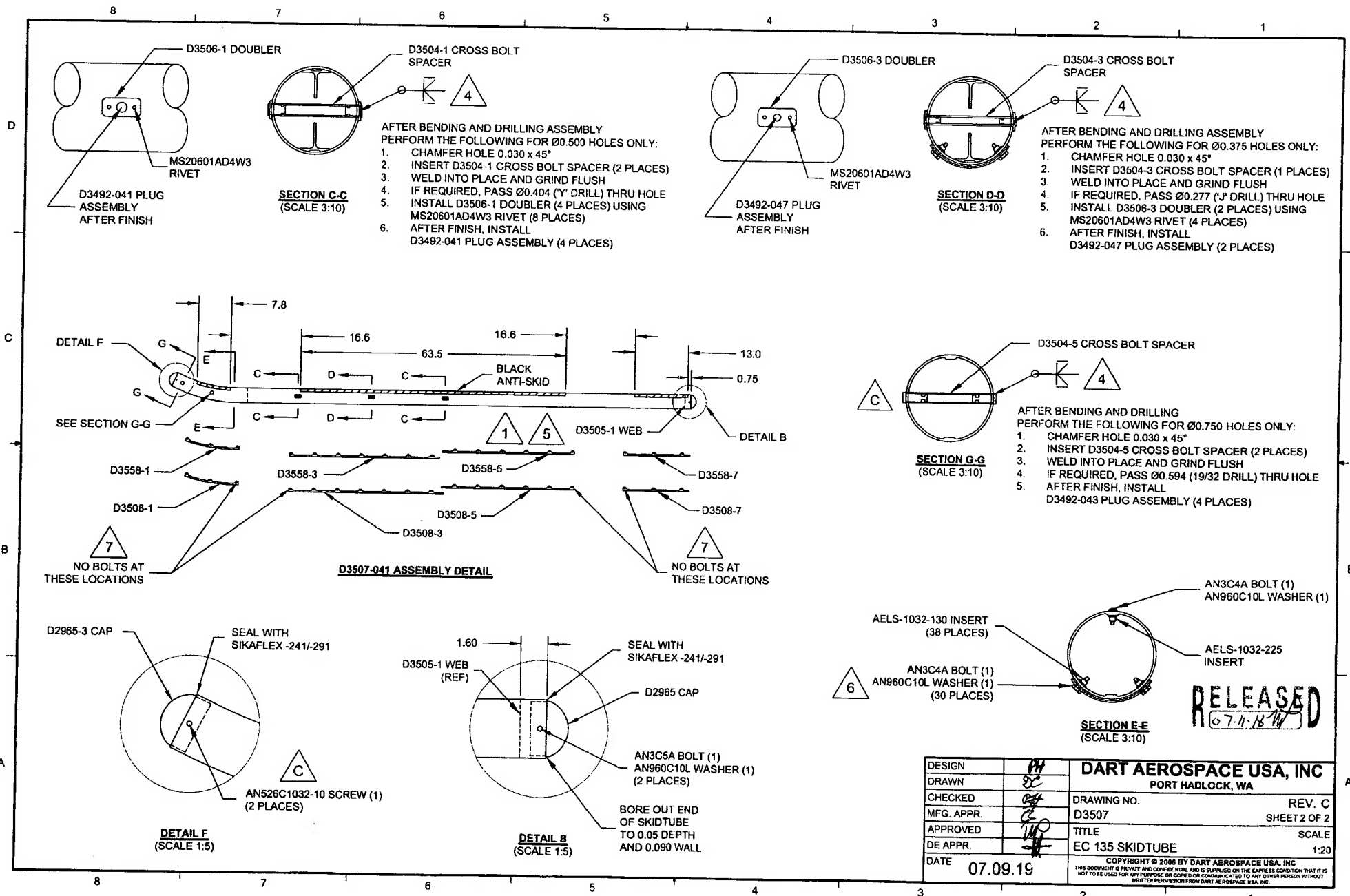
GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8869 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 REV. C SHEET 1 OF 2 TITLE EC 135 SKIDTUBE SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	PC		
CHECKED	PH		
MFG. APPR.	PC		
APPROVED	PH		
DE APPR.	PC	DATE 07.09.19	

RELEASED
07.11.16

W/O Keller



DESIGN	14	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	CH	DRAWING NO.	REV. C
MFG. APPR.	CE	D3507	SHEET 2 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	14	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE, AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

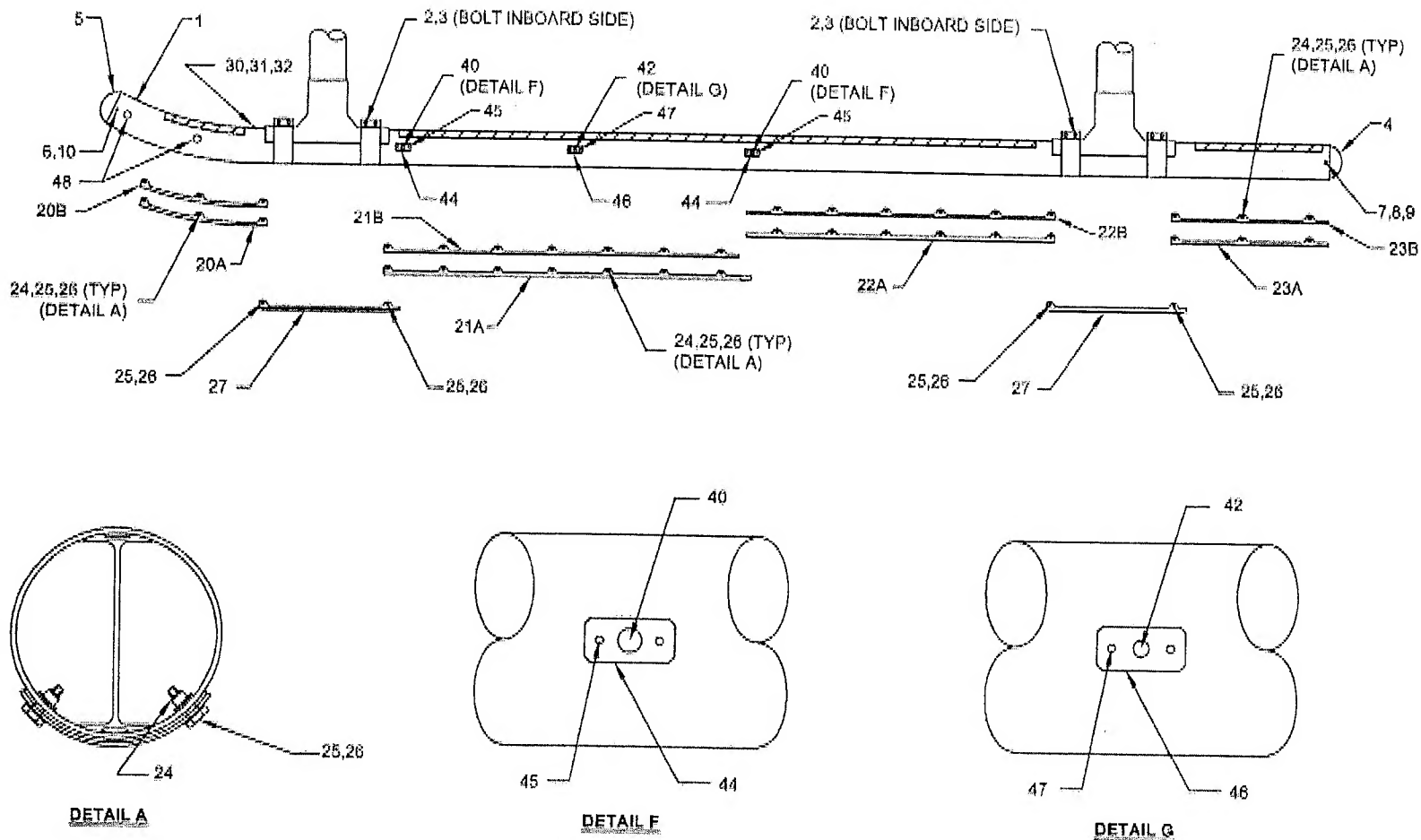


FIGURE 2 - D135-751-011 SKIDTUBE INSTALLATION

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Revision: C

Date: 07.09.20

